

What is claimed is

1. A process for producing cling-fastener parts with a large number of interlocking means (24), characterized in that a formulation encompassing radiation-crosslinkable prepolymers is molded, cast, and/or compression molded into the shape of a large number of interlocking means (24) together with a cling-fastener base (21), and is then radiation-cured.
2. The process as claimed in claim 1, characterized in that the radiation-crosslinkable, in particular acrylic, prepolymers are selected from the group consisting of polyester acrylates, epoxy acrylates, polyether acrylates, silicone acrylates and urethane acrylates, the urethane acrylates preferably being aliphatic mono-, bi- or trifunctional urethane acrylates.
3. The process as claimed in claim 1 or 2, characterized in that the formulation encompasses reactive diluents, preferably monomers, particularly preferably acrylates, the acrylates preferably being monofunctional acrylates from the group consisting of butyl acrylate, 2-ethylhexyl acrylate, hydroxyethyl acrylate, hydroxypropyl acrylate, 4-hydroxybutyl acrylate, ethyl diglycol acrylate, isodecyl acrylate and 2-ethoxyethyl acrylate, and the bifunctional acrylates being from the group consisting of diethylene glycol diacrylate, dipropylene glycol diacrylate, triethylene glycol diacrylate, tripropylene glycol diacrylate and 1,6-hexanediol diacrylate, and the trifunctional acrylates being from the group consisting of trimethylolpropane triacrylate and pentaerythritol triacrylate, and particular preference being given to 2-ethoxyethyl acrylate,

isodecyl acrylate, 1,6-hexanediol diacrylate and trimethylolpropane triacrylate.

- 5 4. The process as claimed in any of claims 1 to 3, characterized in that the radiation curing takes place by way of an electron beam.
- 10 5. The process as claimed in any of claims 1 to 3, characterized in that the radiation curing takes place by way of UV radiation, and the formulation preferably also encompasses at least one photoinitiator.
- 15 6. The process as claimed in claim 5, characterized in that the photoinitiator is selected from the group consisting of α -hydroxyketones, α -aminoketones, dimethylketals of benzil, bisbenzoylphenylphosphine oxides, metallocenes, and derivatives of these, and is preferably 2-hydroxy-2-methyl-1-phenylpropan-1-one.
- 20 7. The process as claimed in any of claims 1 to 6, characterized in that the molding, casting or compression molding takes place in a gap (16) between a shaping roll (11) and a backing roll (12), and that the shaping roll (11) has a large number of radial cutouts (17), where the interlocking means (24) or the protruding elements are formed during passage through the gap (16).
- 25 8. The process as claimed in claim 7, characterized in that the viscosity of the formulation at 25°C is from 150 to 20,000 mPa.s, preferably from 300 to 5,000 mPa.s.
- 30 9. An apparatus for producing cling fasteners as claimed in any of claims 1 to 8, characterized in that the apparatus encompasses a means of feeding (32, 10) for the formulation (14) encompassing
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